

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 34632		
Estimate Number	: 10836		
P.O. Number	: N/A	Part Number	: D29391
This Issue	: 9/12/2007      S.O. No. : N/A	Drawing Number	: D2939 REV C
Prsht Rev.	: NG	Project Number	: N/A
First Issue	: N/A      Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 34163	Material	: N/A
Written By	: _____	Due Date	: 10/5/2007      Qty:      8 Um:      Each
Checked & Approved By	: _____		
Comment	: Est: B    00.06.26    New DWG rev (mpp 2069)    EC		
	: Est Rev:C As per Rev C 07-03-19 JLM		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Issue material from stock: 7075-T7351 QQ-A-250/12  
Cut Size 2.0 x 6.25 X 6.00  
Grain Along Long 6.00 Length  
Batch No: 1334643

20 HAAS1 HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly,

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

## 5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

40 QC1 INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

1998

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:16:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 34632

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FL 07-11-26

(1)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/11/26 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 07/11/26 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. J.

07/11/27 (8x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/11/27 SQ (8x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27

Job Completion



07/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34632
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.117	0.118	0.118	0.118		
B	0.100	0.140		0.117	0.118	0.119	0.120		
C	0.100	0.140		0.125	0.130	0.130	0.130		
D	0.210	0.230		0.219	0.219	0.219	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.122	0.123	0.123	0.123		
O	0.540	0.560		0.557	0.548	0.547	0.549		
P	0.490	0.510		0.501	0.502	0.502	0.501		
Q	3.715	3.725		3.720	3.717	3.717	3.717		
R	2.720	2.760		2.744	2.740	2.740	2.740		
S	0.240	0.270		0.250	0.248	0.248	0.248		
T	0.100	0.180		0.145	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.629	1.628	1.628		
V	1.362	1.372		1.368	1.366	1.366	1.365		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.261	1.262		
Y	1.565	1.585	DT8695 A/B	1.572	1.571	1.572	1.572		
Z	0.178	0.198		0.180	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA / One
Date:	07/11/24

Audited by:	SA
Date:	07.11.24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34632
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C	Page 1 of 1

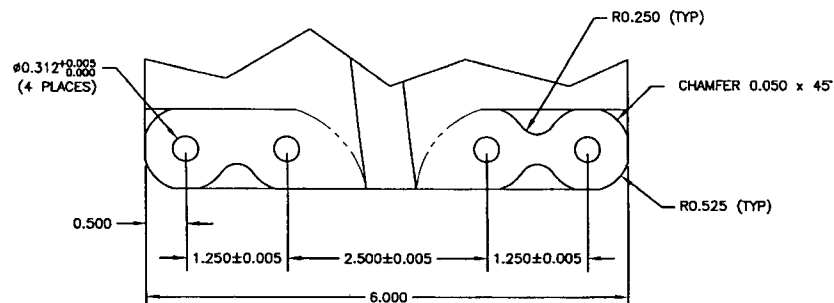
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.119	0.119	0.119	0.118		
B	0.100	0.140		0.116	0.118	0.118	0.116		
C	0.100	0.140		0.130	0.131	0.132	0.133		
D	0.210	0.230		0.221	0.221	0.226	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.123	0.124	0.124	0.124		
O	0.540	0.560		0.548	0.548	0.548	0.548		
P	0.490	0.510		0.502	0.502	0.502	0.502		
Q	3.715	3.725		3.718	3.717	3.718	3.718		
R	2.720	2.760		2.740	2.746	2.740	2.740		
S	0.240	0.270		0.248	0.248	0.248	0.248		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.627	1.627	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.365		
W	0.316	0.321		0.326	0.320	0.320	0.326		
X	1.250	1.270		1.261	1.261	1.261	1.262		
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.571	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>MD</i>
Date:	07/11/25

Audited by:	<i>EC</i>
Date:	07-11-26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

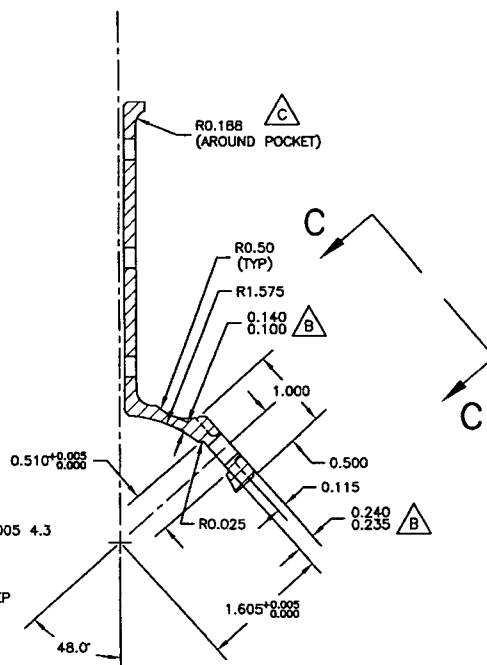


VIEW C-C

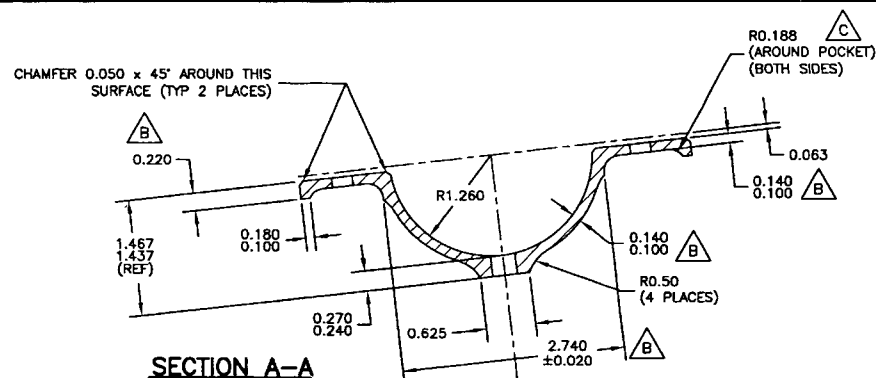
D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

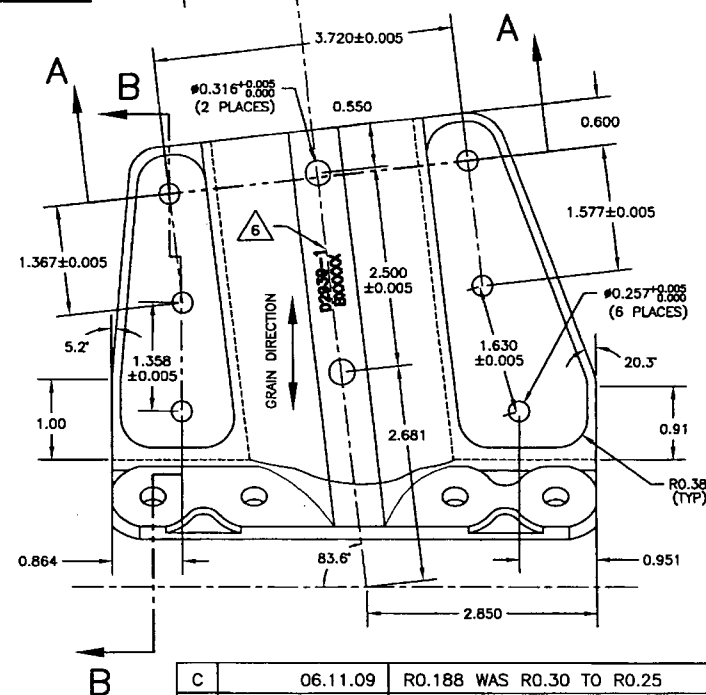
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE 2:3
06.11.09	SADDLE INSIDE	

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NO. 34632

07.02.12